

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019525**Date Inspected:** 25-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

Notification no: 008288.

OBG Seg 14W:

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG components. The weld designations reviewed are as follows:

1) SEG3020K-012, 024.

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

Repair welding / weld built up on Pier E2 stiffener plate (X4468B). The welder is identified as 067876 and was

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

observed welding in the 3G position. Welding process was identified as Flux Cored Arc Welding (FCAW). ZPMC QC was identified as Mr. Qiu Wen. The welding variables recorded by this QC appeared to comply with WPS: 345-FCAW-3G(3F)-ESAB-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 20065 Rev-0. See attached photo for further information.

OBG Seg 13BW:

The FCAW process on weld joint no: SEG3014-009 [Deck Panel (DP) 3130A to Corner Assembly (CA) 3015A, complete joint penetration (CJP) weld]. The welder is identified as 066734 and was observed welding in the 1G position. ZPMC QC was identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS: B-T-223(2)1T-ESAB-1.

Repair welding of weld joint nos: SEG3014D-306 and 310 [Floor Beam (FB) 3212A to I-rib stiffener on Side Panel (SP) 3104A, CJP weld at PP121.5]. The welder is identified as 045196 and was observed welding in the 3G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Sun Tian Liang. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per welding repair report (WRR): B-WR 20191 Rev-0.

Repair welding of weld joint nos: SEG3014D-336 and 340 (FB3212A to I-rib stiffener on SP3105A, CJP weld at PP121.5). The welder is identified as 045196 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Sun Tian Liang. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per WRR: B-WR 20191 Rev-0.

OBG Seg 13CW:

The Submerged Arc Welding (SAW) process on weld joint no: SEG3015-007 (DP3143A to CA3016A, CJP weld). The welder is identified as 250050 and was observed welding in the 1G position. ZPMC QC was identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS: B-T-223(2)1T-ESAB-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer